108778

Page 1

October-29-13 10:02:09 AM

Item ID: D2971

Accept

N900040100

Setup Start

Stop

NS2

Revision ID:

Item Name: Cross Bolt Spacer

Start Date: 10/29/13 **Required Date: 10/29/13** **Start Qty: 40.00** Req'd Qty: 40.00 *40* *40*

Cust Item ID:

Reference:

Approvals:

Date: 13-10-31

Start Run

Stop

QC:	Date:	_ SPC (Y/N)	Date:		Stop *	NR2*
Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID Tool #	Plan Accept Code Qty	Reject Reje Qty Nun	ect Insp. nber Stamp
Draw Nbr	Revision Nbr	•		÷.		
D2971	Rev A1	•	•			*:
*100 *100* Hardinge Hardinge CNC Lathe Small	Hardinge CNC LATHE SMALL Memo as per Dwg D2971 & Folio FA288	0.00 QA S	13/u /12	40	Ø	
*110 *110* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00 40 9-89	13/11/12	40	Ø	
120 *120* QC	QC8- Inspect parts - second check Memo	0.00	13/11/12	40	<i>\(\begin{array}{cccccccccccccccccccccccccccccccccccc</i>) 08 08

Quality Control

DQA:			Date:			WORK ORDER NON-CONFORMANCE / UPDATE									
QA Closed:			Date:			WORK ORDER NON-	-((JNFOI	RIVIANCE / UI		Wor	k Order up	date only		AEROSPACE
Work Orde	ır.					DISPOSITION				AGAINST I	DEP.	ARTMENT,	PROCESS		
Part N						Rework Scrap Use-as-is Suspected Unapproved		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite			Prod. Eng. Coor. Rec/Store/Packaging				Engineering Quality Other
Root					Desci	ription of work order update		nitial	Act	ion		Sign &			
Cause	lo	ate	Step	Qty		or non-conformance	ı	ief Eng		iption		Date	Verification	۱ ۱	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved									T.CODY						
Londin							FAI	ULI CA	TEGORY						
Landir	Cer Cra Crir Cuf Cru Hea Insp	nding otre No cks mp/Kin fs shing ot Trea pection rks/Ch	Strip in	/Wave Tube		General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardwa Inspect Instruct Misalig Mislabe Misread Off-set	ion Incomplete/Unions Incomplete/Unions Incomplete/Unions Incomplete/Unions Incomplete	·		Outside Dim Over/Under Part Incorrec Part Lost/Mi Part Moved Positioned W	tolerance ct ssing Vrong		Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other
			ist in Tub			Fit/Function	\vdash	4	Sequence		-	-			
						1	1		1-1-11-						

October-29-13	10:02:09 AN	<i>1</i>					_	<u>-</u> _				4
Item ID: Revision ID:	D2971			Accept	*N900	040	100)*	Setup	Start Stop	*N	S1*
Item Name:	Cross Bolt S	-	*40*			_				•	1/1	S2*
Start Date: Required Date:	10/29/13	Start Qty: 40.00 Req'd Qty: 40.00	*40*		Cust Item I	D:						
Reference:	. 10/29/13	Req u Qiy. 40.00	*40*		Customer:							
Approvals:	Process Pl	lan:	Date:	Tooling:	D	ate:	···		Run	Start	*N	R1*
	QC:		Date:	SPC (Y/N):	D	ate:				Stop	*N	R2*
Sequence ID/ Work Center I	D	Operation Description	1/1	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	t Rej Qty		Reject Number	Insp. Stamp
130		Identify as per dwg & Sto	ock Location:	0.00				-14		,		
130 Packaging Packaging		Memo ***STOCK	IN SKIDTUBE CELL***	0.00				40		<u>e</u>	_ <i>13-11</i>	H DG
								-		1		
140		QC21- Final Inspection -	Work Order Release	0.00						12/	11/15	XXX -
*14 0 *				0.00						17/1	1/10	
Quality Control		Мето		0.00							m	8/11-13

DQA:		_ Date:			-								**) A DT
QA Closed:		Date:			WORK ORDER NON-	-C(ONFO	RMANCE / UF		Work (Order ur	odate only		AEROSPACE
	·	- Dute.					<u> </u>				· · · ·			
Work Orde	er:				DISPOSITION				AGAINST [DEPAR	TMENT	/PROCESS		
	-				Rework			Skid-tube	Crosstube			Water Jet	Eng	ineering
Part N	۱o				Scrap]	Machining	Small Fab		Pro	d. Eng. Coor.	7 ~	Quality
					Use-as-is		Thern	noforming	Finishing		Rec/Stoi	re/Packaging		Other
NCR N	No				Suspected Unapproved			Large Fab	Composite			Supplier		
Root				Desc	ription of work order update	1	Initial	Acti	ion	S	ign &			
Cause	Date	Step	Qty		or non-conformance		nief Eng	Descri		1	Date	Verification		C Inspector
Design								•						
Doc/Data														
Equip/Tooling										ļ				
Handling/Pre														
Material														
Operator													-	
Offset/Setup													Î	
Process														
Supplier														
Training													ŀ	
Transport														
Unapproved														
						FA	ULT CAT	TEGORY						
Landir	ng Gear				General		_					-		
	Bending	·			Bend		Folio/P	rogram		Out	side Dim	ensions	Pressi	ure/Forced
	Centre N	ot Concer	ntric		BOM/Route		Grain			Ove	r/Under	tolerance	Set-u	р
	Cracks				Broken/Damage/Defect		Hardwa	re	[Part	Incorrec	ct [Temp	erature/Cure
	Crimp/Ki	nk/Ripple	/Wave		Burrs		Inspecti	on Incomplete/Un	qualified	Part	Lost/Mi	ssing .	Weld	
	Cuffs				Contamination	L	Instruct	ions Incomplete/U	Inclear	Part	Moved	Γ	Wron	g Stock Pulled
	Crushing				Countersink		Misalig	ned/off center		Pos	tioned V	Vrong		
	Heat Tre				Cut Too Short		Mislabe	led		Pow	er Loss/	Surge	Other	
	Inspection	n Strip in	Tube		Drawing		Misreac	I	_					
	Marks/C	hatter			Drill Holes		Off-set							
	Turning 9	Sequence			Finish		Out of 0	Calibration						
	Wave/Tv	vist in Tub	e e		Fit/Function		Out of S	Contionco						

Picklist Print

October-29-13 10:02:09 AM

Work Order ID:

108778

Parent Item:

D2971

Parent Item Name:

Cross Bolt Spacer

Start Date: 10/29/13

Required Date: 10/29/13

Page 1

Start Qty: 40.00

Required Qty: 40.00

Comments:

IPP B02.11.04Re-format; Ø0.875"" x 0.058"" was Ø0.625"" x 0.065""KJ

Component Item ID/	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.875W.058 6061-T6 RD Tube .875 X	058W	Purchased	No			100	f	50.6680	0.2833	11.92842	LDAS_	13/	/U/1Z
	.065W			Location		Loc Oty	<u>Lo</u>	c Code		•	40	,	
		. 11.		MAT015		50.668					()		
1	- Atch	offy		1078	37	50.668							
/ //	- 410				7.4				1	110			

→ 17710 107710

4.0

9.0

DQA:			Date: _			MORK ORDER MON				DD 4 TE				DART
QA Closed:			Date:			WORK ORDER NON-	-C(JNFOI	RIMANCE / UI		Vork Orde	r upda	ate only	AEROSPACE
Maril Ord						DISPOSITION				AGAINST D	EPARTME	NT/PR	ROCESS	
Work Orde	er: —				-	Rework			Skid-tube	Crosstube	7		Water Jet	Engineering
Part N	lo.					Scrap		ı	Machining Vacanting	Small Fab	-		Eng. Coor.	Quality
, are i					_	Use-as-is			noforming	Finishing			Packaging	Other
NCR N	lo					Suspected Unapproved			Large Fab	Composite			Supplier	
Root					Desci	ription of work order update		nitial	Act	ion	Sign 8	ų l		
Cause	D	ate 👯	Step	Qty		or non-conformance	Ch	ief Eng	Descr	iption	Date	\\	Verification	QC Inspector
Design	_	-				, ,								
Doc/Data														
Equip/Tooling	_													
Handling/Pre	_			,										
Material														
Operator	_													
Offset/Setup	\dashv													
Process														
Supplier														
Training	-													
Transport	\dashv													
Unapproved							<u> </u>	UTCAT	EGORY					<u> </u>
Landir	ng Gear					General	FA	OLI CA	EGORT					
[ding				Bend		Folio/P	rogram	Γ	Outside	Dimens	sions	Pressure/Forced
		tre Not	Concen	tric		BOM/Route		Grain	· og. um	<u> </u>	Over/Un			Set-up
	Cra					Broken/Damage/Defect		Hardwa	re	-	Part Inco		-	Temperature/Cure
		np/Kink/	/Ripple/	/Wave		Burrs		ł	on Incomplete/Ur	ngualified	Part Lost		ng 📙	Weld
	Cuff		• • •			Contamination		1	ions Incomplete/U	<u> </u>	Part Mov			Wrong Stock Pulled
	Cru	shing				Countersink		1	ned/off center	<u> </u>	Position		∟ ong	1 0
	_	t Treat				Cut Too Short		Mislabe			Power Lo			Other
	Insp	ection S	Strip in	Tube		Drawing	Г	Misread		L.	_	- '		
	_	rks/Chat				Drill Holes	П	Off-set		·				
	Turi	ning Seq	luence			Finish		Out of (Calibration					
	Wa	ve/Twist	t in Tub	e		Fit/Function		Out of S	equence					

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

DART AEROSPACE LTD	Work Order:	108778
Description: Crossbolt Spacer	Part Number:	D2971
Inspection Dwg: D2971 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	F	rototype
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Drawing	Tolerance	Actual	Accept	Reject	Method of Inspection	Comments
Dimension		Dimension		.,		_
3.400	+0.030/-0.000	3,415			VERN	PL10-12
Ø0.875	+/-0.010	, 875			u	n
0.058	+/-0.010	.061	V		ıc	4
						·
						·

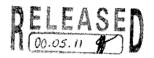
	(DAS		4			
Measured by:	40	Audited by:	À.A	0AS 08	Prototype Approval:	N/A
Date:	13/11/12	Date:	13/11/12	S-89	Date:	N/A

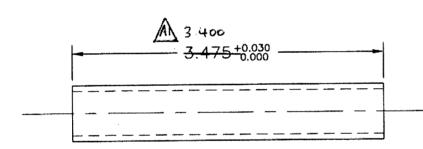
Rev	Date	Change	Revised		Approved
Α	08.04.16	New Issue	KJ/DD	old-	
	1			77	

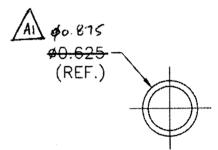




DESIG	r Pr	DRAWN BY	DART AEROSPACE USA INC.
CHECK	(E)	APPROVED	D2971 SHEET 1. OF 1
DATE			TITLE SCALE
00.0	3.13	State of	CROSS BOLT SPACER 1:1
Α		00.03.13	NEW ISSUE
Aı	4-40	02-10.30	CHANGE TO 0.875 00 × 0.058 WALL







0.875 DIA × 0.058 WALL (A)



MATERIAL: 6061-T6 (WW-T-700/6) 0.625 DIA. x 0.065 WALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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